

Date: Monday, 09/03/2009 1:42:00 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPLATE		
Job Number	: 46326			Part Number	: D25775		
Estimate Number	: 10299			Drawing Number	: D2577 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 09/03/2009 S.O. No. :			Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 31/03/2009 Qty: 10 Um: Each		
Previous Run	: 32650						
Written By	:						
Checked & Approved By	: <u>JUL 09.03.09</u>						
Comment	: Est: F 02.09.24 Re-format KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S16GA	1010/1025 sheet 16GA	
		Comment: Qty.: 1.0301 sf(s)/Unit Total : 10.3005 sf(s) 1010/1025 16GA SHEET (m1010s16ga) Batch: <u>iOS706</u> <u>FB 9-3-12</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2577 Dwg Rev: <u>E</u> <u>FB 9-3-12</u> Prog Rev: <u>E</u> <u>11</u>	
		2-Deburr if necessary <u>FB 9-3-12</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>FB 9-3-12</u> <u>11</u>	
		Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-5T1	
4.0	QC8	SECOND CHECK	
		<u>10/03.12</u> <u>11</u>	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>N/A</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:42:00 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46326

Part Number: D25775

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

SB 09/03/16 (11)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/16 (P10)

8.0 POWDER COATING POWDER COATING



m 1091648

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

(X11)

START TIME: 13:05

OVEN TEMPERATURE: 320°

FINISH TIME: 13:35

cmo/Fx

09/03/17

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



sl

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-17 X (11)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W22

Reg/3/17 (11)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



09/03/18 (11)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46326
Description: Wearshoe	Part Number:	D2577-5
Inspection Dwg: D2577 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HR
Date:	9-3-17

Audited by:	
Date:	✓ 5/3/12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.12.07	New Issue	KJ/JLM	E

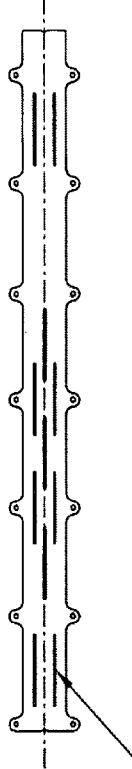
DART

DESIGN <i>SP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>SP</i>	APPROVED <i>SP</i>	DRAWING NO. D2577	REV. E SHEET 1 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO O-BROUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

RELEASED

00.09.26 SP

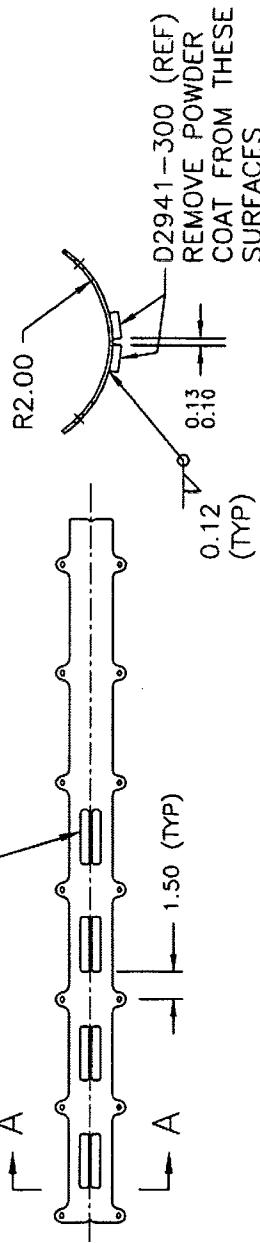
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PL.S.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING 10-300
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 10308
SHWAYDER WEAPADS
(8 PLACES)

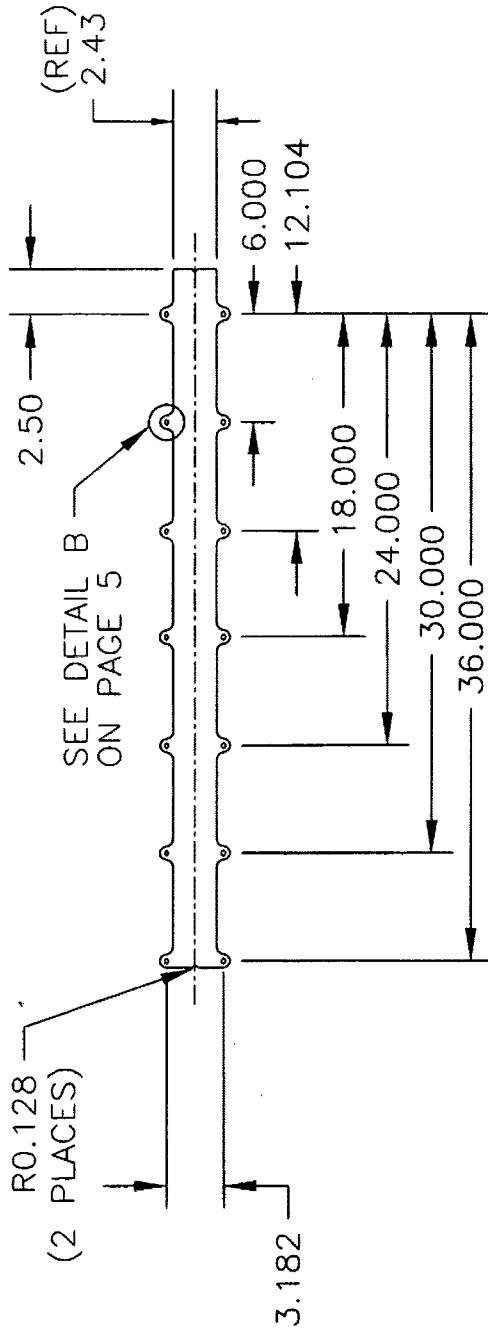
SECTION A-A
SCALE 1:5

D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

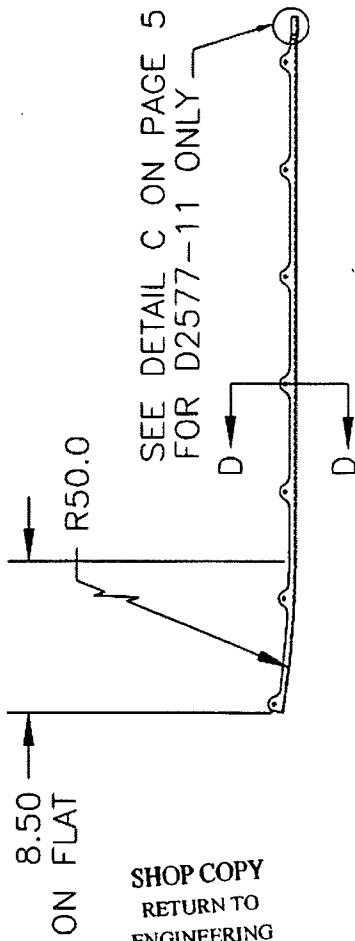
DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D2577	
DATE 00.09.22	TITLE WEARSHOE		REV. E SHEET 2 OF 5 SCALE 1:10

D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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WORK ORDER
No Hold

D2577-11 & D2577-13 LONGITUDINAL BEND

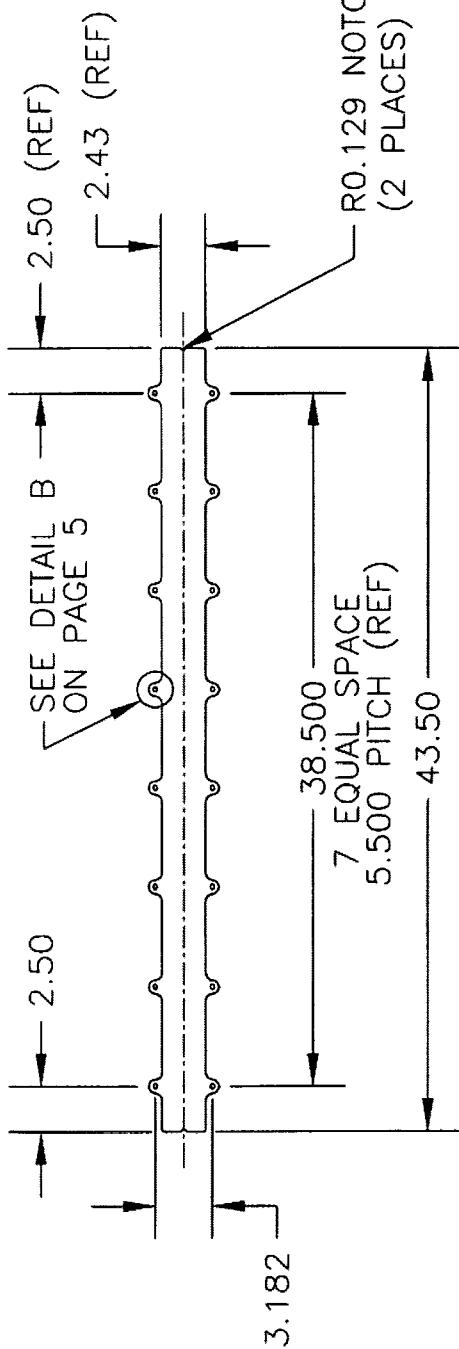
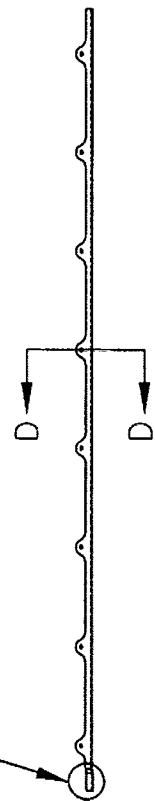
MAKE FROM D2577-101
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED <i>CH</i>	APPROVED <i>MM</i>	DRAWING NO. D2577	REV. E SHEET 3 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

D2577-5 FLAT PATTERND2577-5 LONGITUDINAL BEND

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WITHOUT NOTICE
WORK ORDER
NO. 46326

D2577-5 WEARSHOE

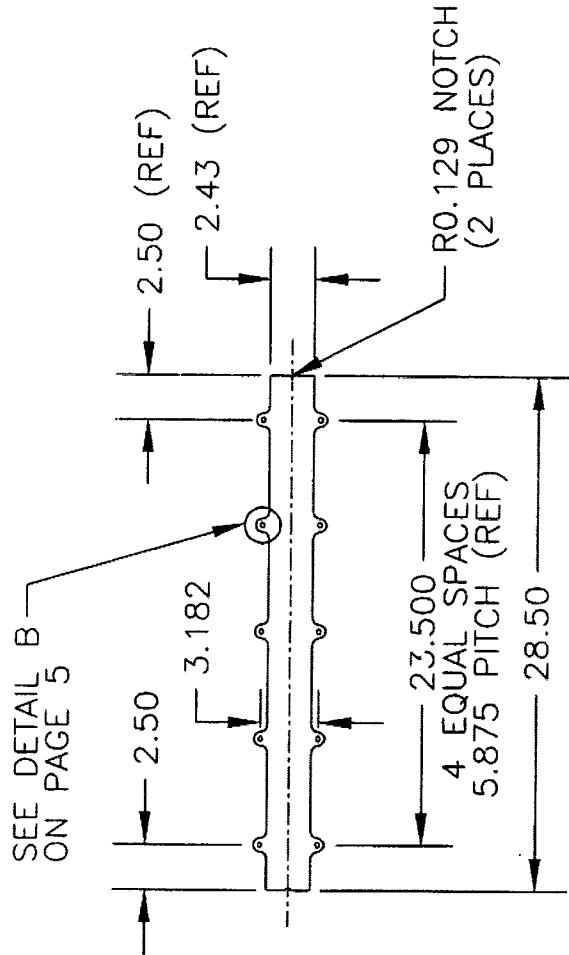
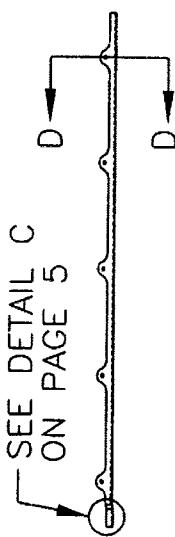
BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A569/A570
SERIES STEEL 0.063 THICK
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2577	REV. E SHEET 4 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00 09 26 *CH*D2577-7 FLAT PATTERND2577-7 LONGITUDINAL BEND

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WITHOUT NOTICE
WORK ORDER
NO. 410326

D2577-7 WEARSHOE

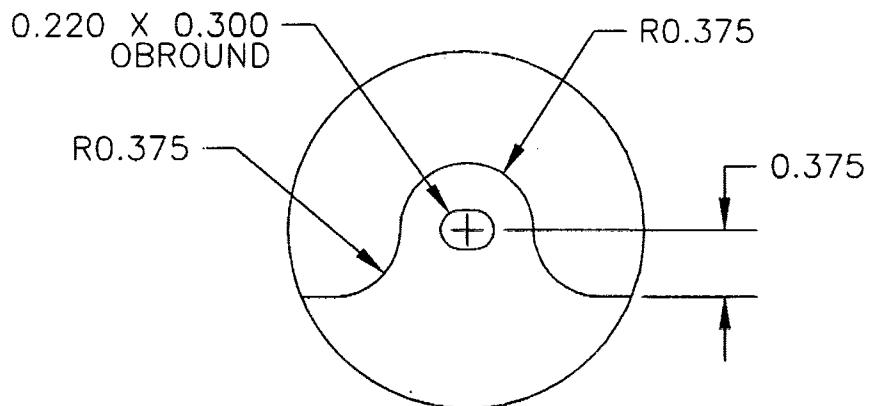
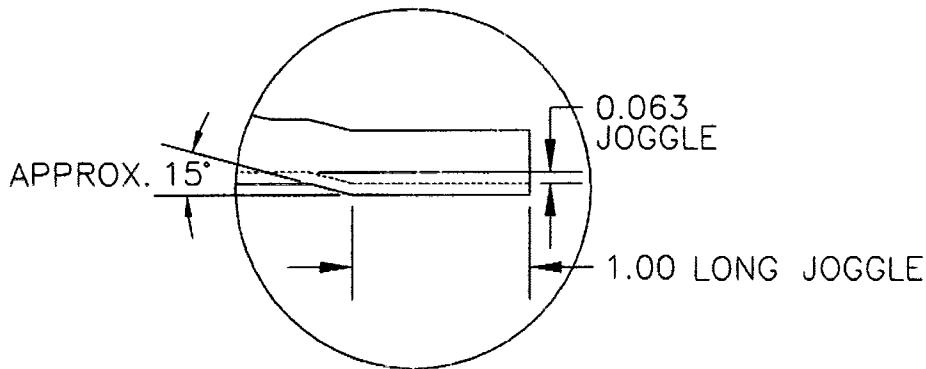
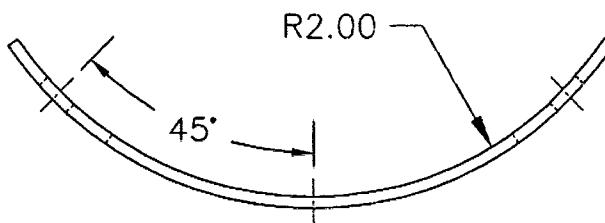
BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
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CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)**RELEASED**
00.09.20DETAIL C (SCALE 1:1)SECTION D-D (SCALE 1:1)

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